

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019665**Date Inspected:** 10-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10:

OBG Bike path, FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053869 Perform Flux Core Arc Welding (FCAW) on OBG Bike path Stringer plate. Joint identified as BK009A7-001-107, 108. ZPMC QC Identified as Deng Zhi Bing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 040302 Perform Flux Core Arc Welding (FCAW) on OBG Bike path Stringer plate. Joint identified as BK009A4-001-008, 009. ZPMC QC Identified as Deng Zhi Bing. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB. For more information see below attached picture number 1.

SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040581, Perform Shielded Metal Arc

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Welding (SMAW) on OBG Traveler rail. Joint identified as 31TR1-001. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 057220, Perform Shielded Metal Arc Welding (SMAW) on OBG Traveler rail. Joint identified as 26TR1-012. ZPMC QC Identified as Xu Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-B-U2.

This QA Inspector observed ZPMC qualified welding personnel identified as 057258, 044511, Perform Shielded Metal Arc Welding (SMAW) on North Tower lift 6, A/B Corner joint. Joint identified as NSD1-TL6-3-19. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T--2212-Tc-U5. For more information see below attached picture number 2.

BAY 11: FCAW process

This QA Inspector observed ZPMC qualified welding personnel identified as 040723, Perform Flux Core Arc Welding (FCAW) on OBG Bike path. Joint identified as BK008A6-002-023, 024, 035, 160. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 046769, Perform Flux Core Arc Welding (FCAW) on Tower lift 6 assembly plate. Joint identified as WSD1-FGSA6-1-23, 24, 21, 22. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh
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Quality Assurance Inspector

Reviewed By:	Clifford,William
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QA Reviewer
